

Date: Friday, 8/4/2006 10:00:56 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING		
Job Number	: 28090		Part Number	: D312123		
Estimate Number	: 10089		Drawing Number	: D3121 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 8/4/2006 S.O. No. : N/A		Drawing Revision	: D		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 8/11/2006 Qty: 50 Um: Each		
Previous Run	: 27645					
Written By	: <i>SKA</i> comment below					
Checked & Approved By	: <i>TD</i> 06.08.04					
Comment	: Est. A: 04.02.19 New Issue KJ/DS					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  
<p>Comment: PURCHASING Issue P/O: <u>1718</u> <i>CL 06/08/04</i> <u>50</u> Bearing as per Dwg D3121 Possible Supplier: SKF P/N: 61900-2Z or KML P/N: 6900-2Z Material release note is required</p>		
2.0	6900ZZ	Bearing  
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Bearing</p>		
3.0	PACKAGING 1	PACKAGING RESOURCE #1  
<p>Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached <i>R 06/08/08</i> <u>50</u></p>		
4.0	QC6	DIMENSIONAL CHECK  
<p>Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3121 and attached certification Dwg Rev <u>D</u> <i>J 06.08.08</i> <u>50</u></p>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1  
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>51409</u> <i>J 06/08/08</i> <u>50</u></p>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: 

Date: 06/08/10

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Friday, 8/4/2006 10:00:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 28090

Part Number: D312123

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

50

Job Completion



A 8/8/06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

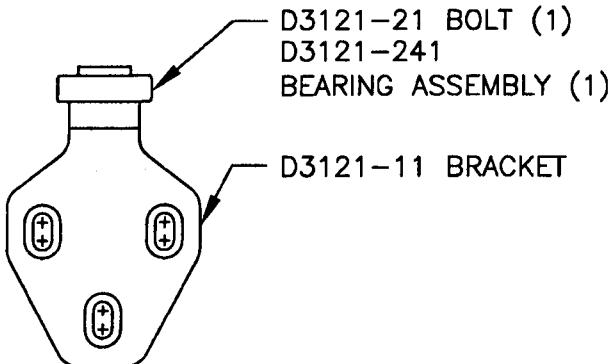
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

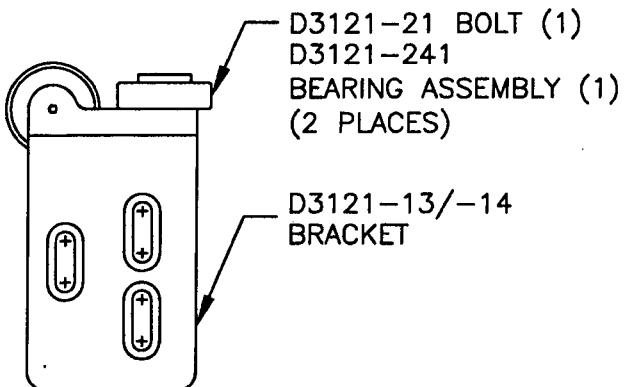
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CHECKED	APPROVED	DRAWING NO.	REV. D SHEET 1 OF 10
		D3121	
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2

RELEASED

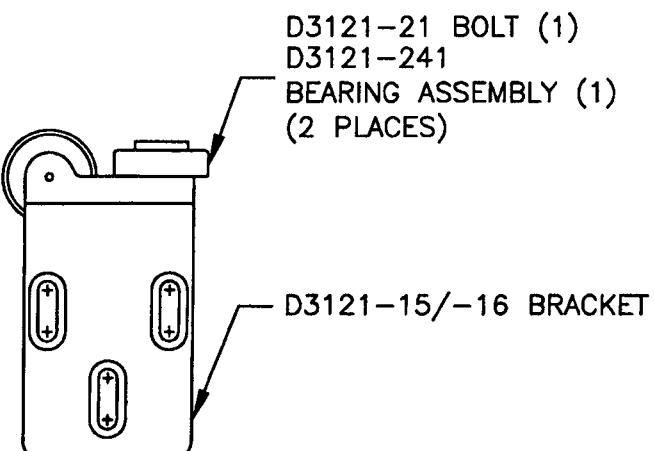
06.06.02 -ff



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

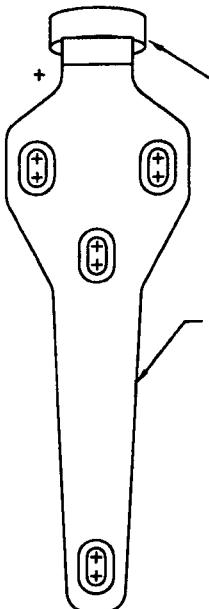
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DATE	06.05.17	TITLE SCALE BRACKET ASSEMBLY 1:2



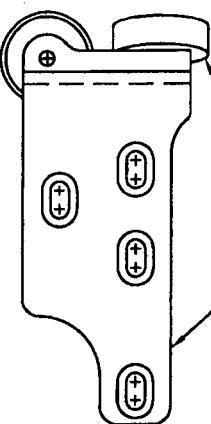
D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

D3121-111 BRACKET

RELEASED

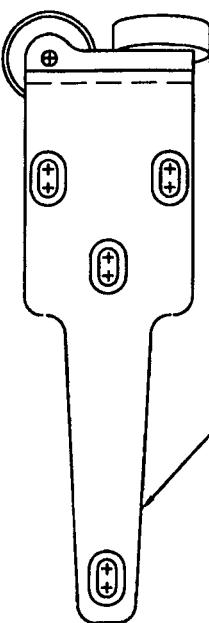
06.06.02 *[Signature]*



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-05/-06)

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DATE		TITLE BRACKET ASSEMBLY

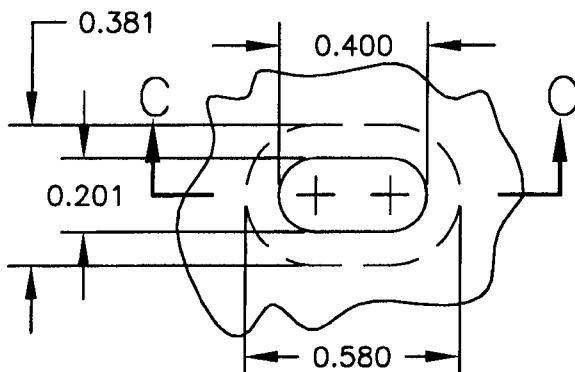
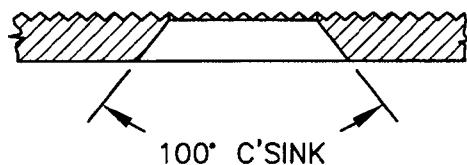
REV. D

SHEET 3 OF 10

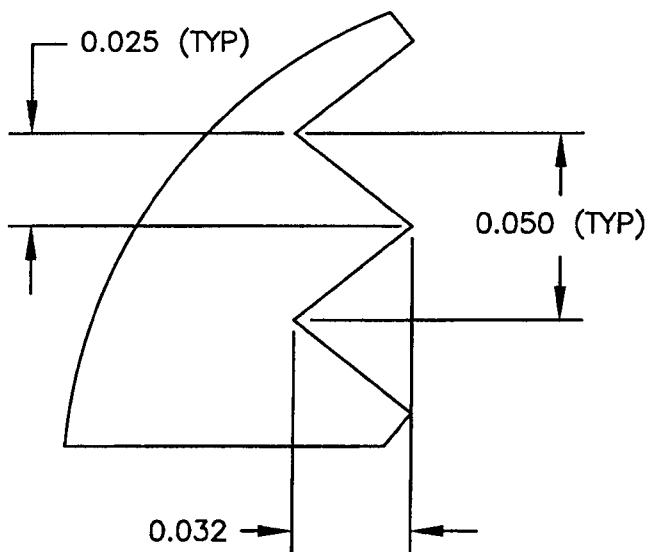
SCALE

1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED

**SECTION
C-C**

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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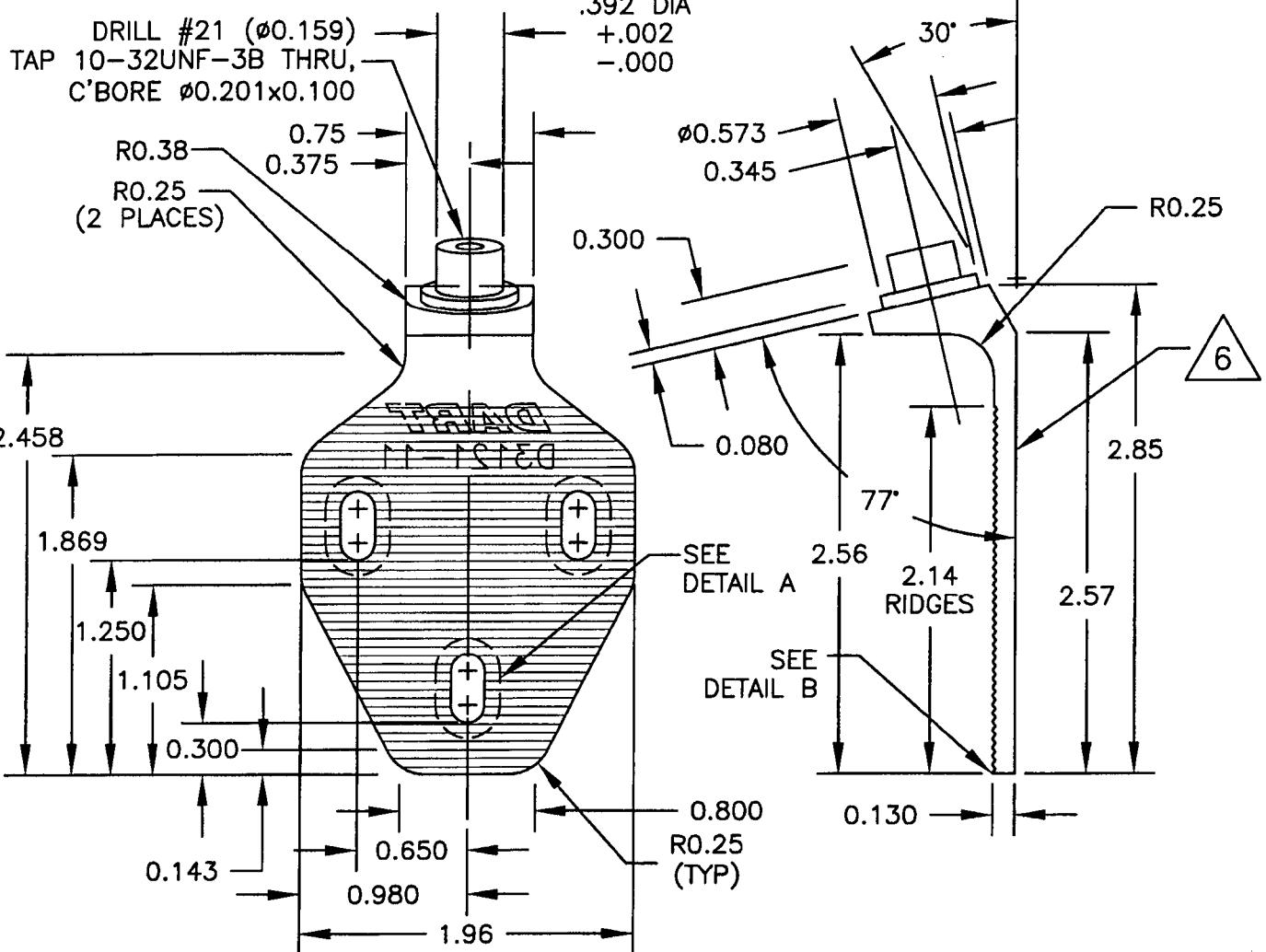
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DATE		REV. D SHEET 4 OF 10 TITLE SCALE 1:1

**D3121-11 BRACKET**

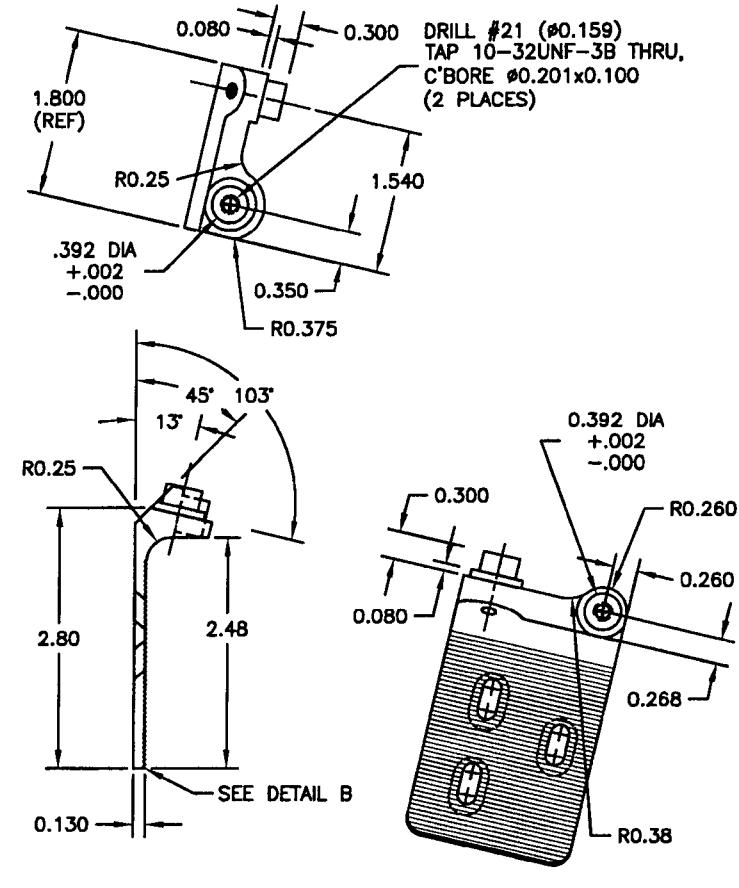
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE	06.05.17	TITLE	SHEET 5 OF 10



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

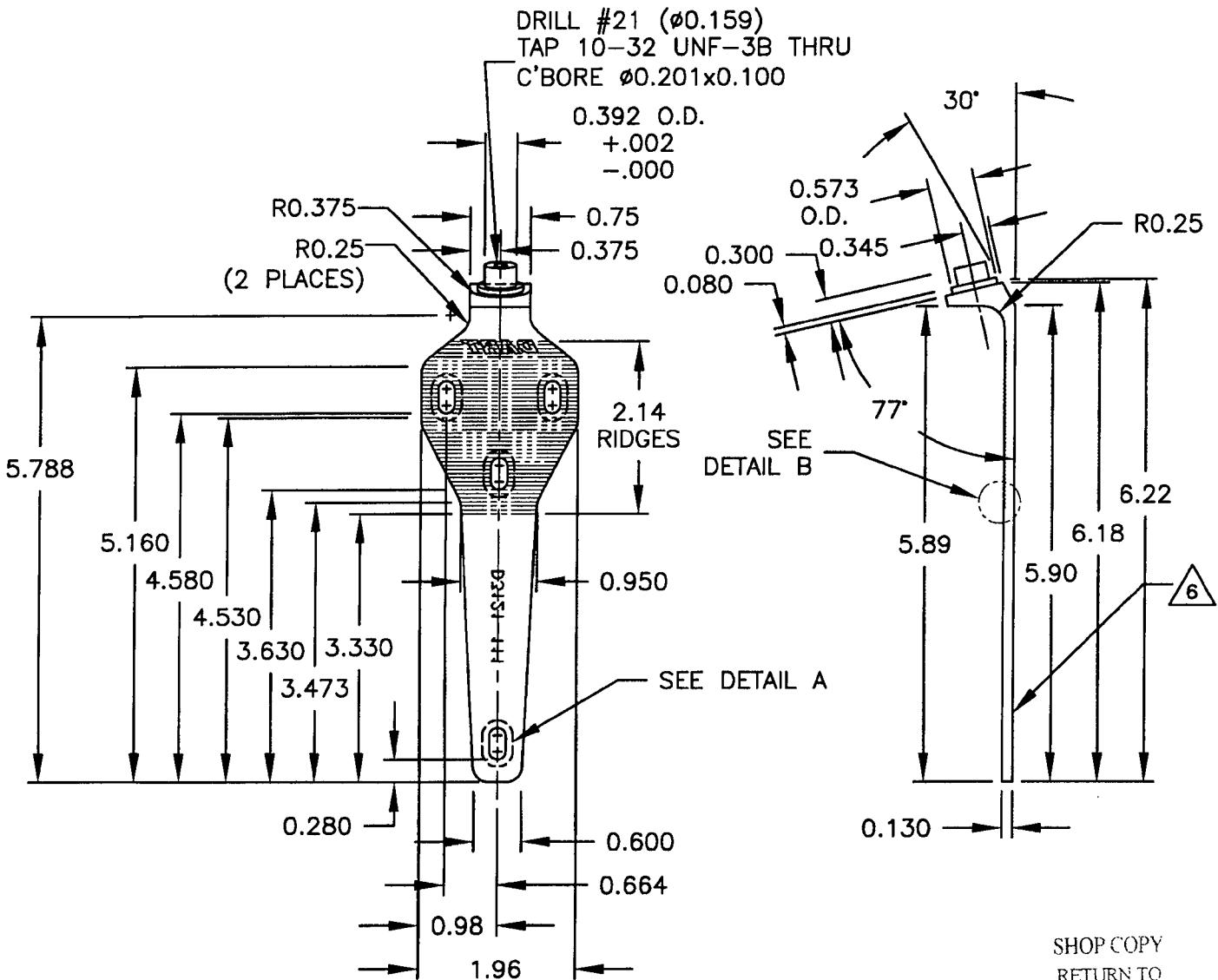
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi
 MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE		REV. D SHEET 7 OF 10 TITLE SCALE 1:2

**D3121-111 BRACKET**

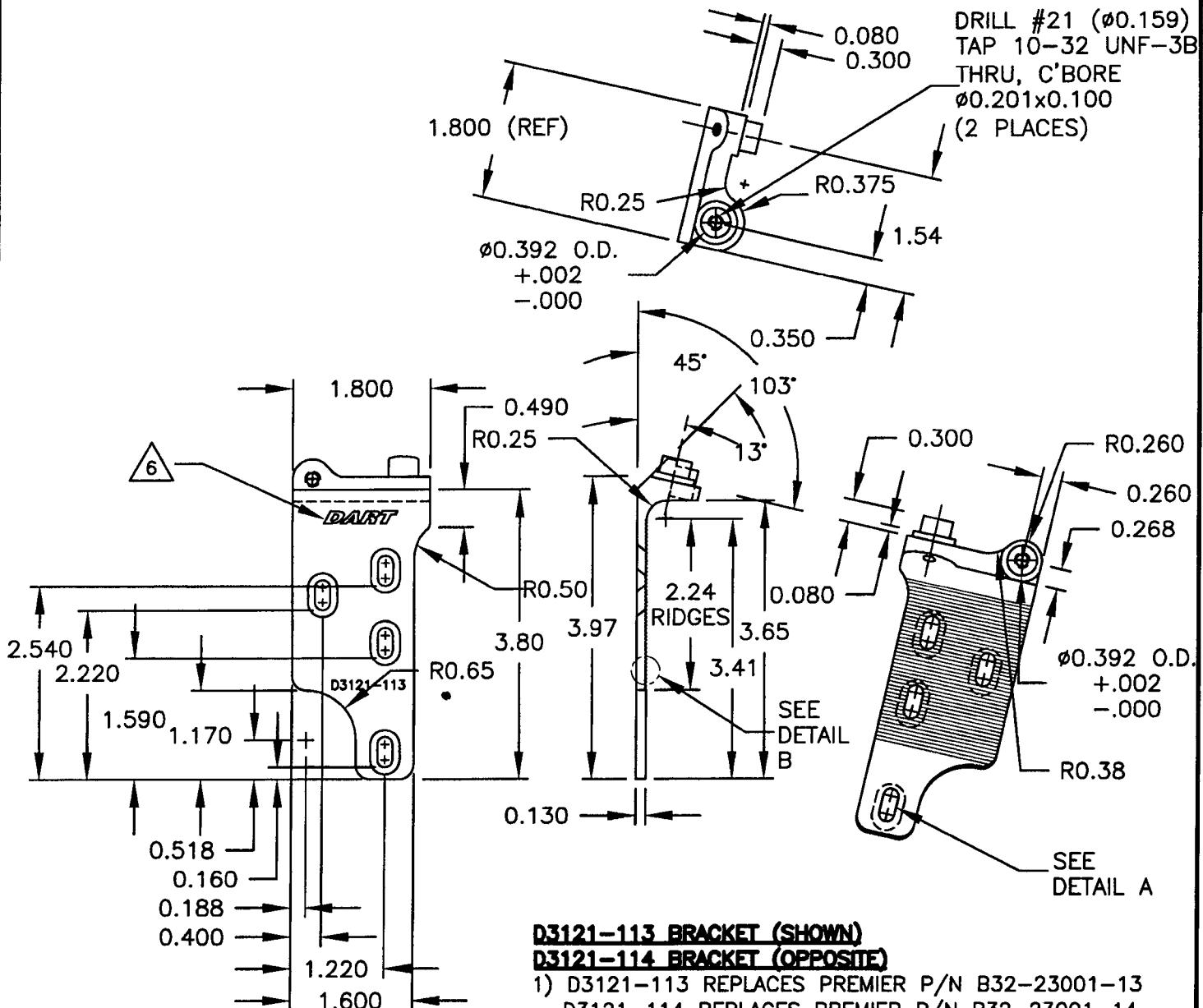
- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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PART

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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2	



**D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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06.06.02 SUBJECT TO AN END DATE
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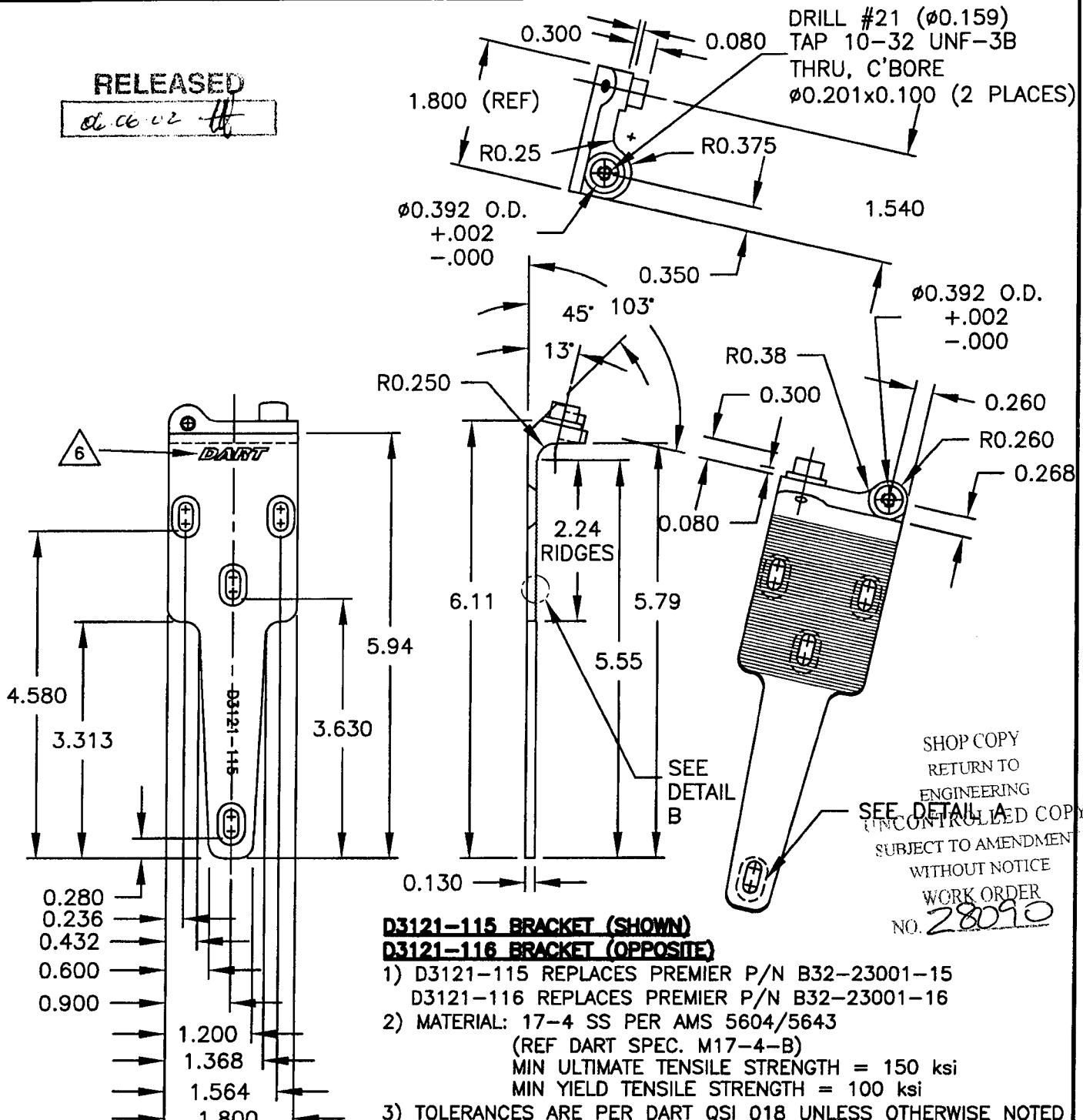
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DATE		D3121	SHEET 9 OF 10
04.02.18		BRACKET ASSEMBLY	SCALE 1:2

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06.06.02

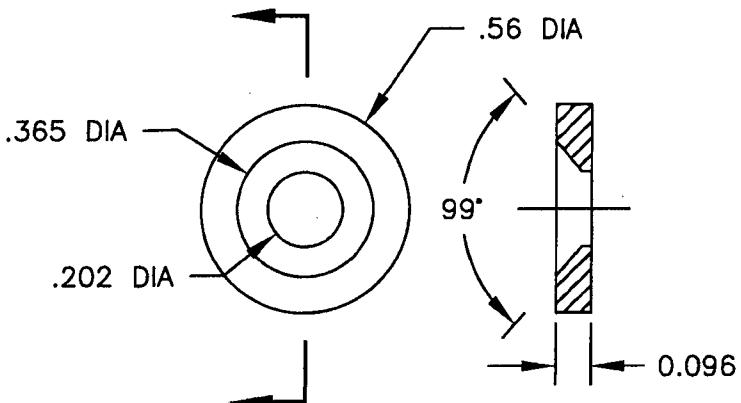


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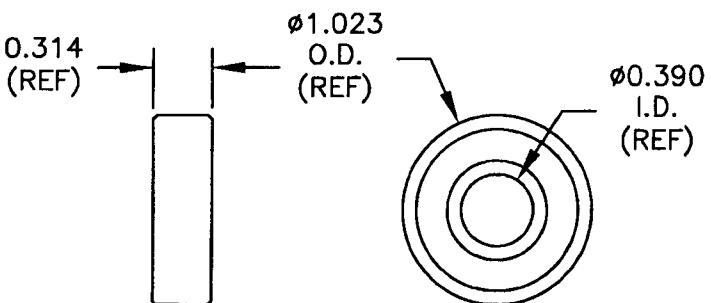
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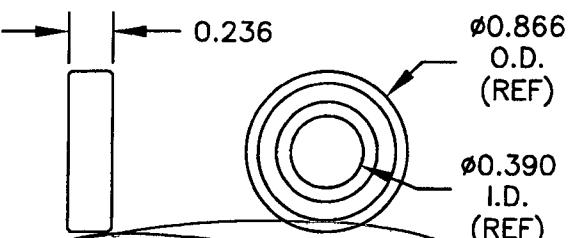
DESIGN	DRAWN BY	DART AEROSPACE LTD	
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DATE		DRAWING NO.	SHEET 10 OF 10
06.05.17		TITLE	SCALE
		BRACKET ASSEMBLY	1:1

**D3121-17 WASHER (SCALE 2:1)**

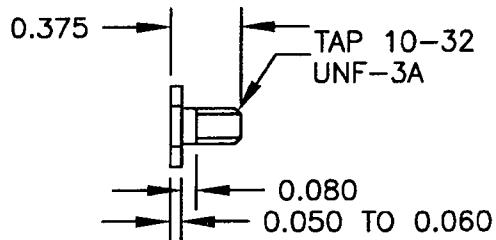
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

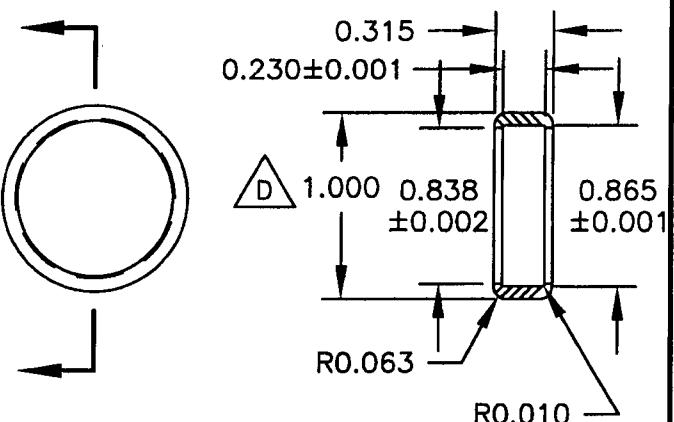
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

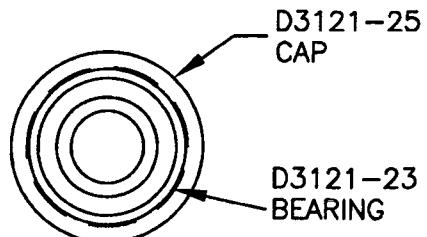
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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GENERAL BEARING SERVICE, INC.

GST # R101979094

SOLD TO: DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY, ON.

K6A-1K7

SALE MADE BY: PD
SHIP VIA:

CUSTOMER ORDER #: P000001778

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6900-2Z	BALL BEARING BALL BEARING	1 50	50	4.89	244.50
6900-2Z		1 50	50	4.97	248.50
					6.51
					29.58

PACKING SLIP NO: 222822-0

RECEIVED BY:

Robert Harbauer

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CIO. GENERAL BEARING SERVICE, INC.

GST # R101979094

SOLD TO: DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY, ON.

К69-1К

GENERAL BEARING SERVICE

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

ORDER DATE: AUG 8, 2006

SALE MADE BY: PD
SHIP VIA:

~~CUSTOMER ORDER #: P00000177~~

PST LICENCE: 6122-520

PRODUCT	DESCRIPTION	QTY SOLD	SHIP TO	PRICE	EXTENSION
6800-77	BALL BEARING	50	50	4.89	244.50
6900-77	BALL BEARING	30	50	4.97	248.50

PACKING SLIP NO: 223164-9

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